

Date: Monday, 23/03/2009 3:02:53 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 46667					
Estimate Number	: 11645					
P.O. Number	:		Part Number	: D29921		
This Issue	: 23/03/2009	S.O. No. :	Drawing Number	: D2992 UNDER REVIEW		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: A		
Previous Run	: 38739		Material	:		
Written By	:		Due Date	: 30/03/2009		Qty: 6 Um: Each
Checked & Approved By	:					
Comment	: Est B 02.93.06 Added dwg Rev.B NG Est Rev:C 08-04-22 now on water jet DD verified by:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M5052H32S040	5052-H32 .040 Sheet		
		Comment: Qty.: 0.0802 sf(s)/Unit Total : 0.4813 sf(s) 5052-H32 .040 Sheet Material: 5052-H32 0.040" sheet Batch: 104921 *		WL 09 03 24 (6)
2.0	WATER JET	FLOW WATER JET		
		Comment: FLOW WATER JET 1-Cut as per Dwg D2992 Dwg Rev: U/R Prog Rev: U/R 2-Deburr if necessary		WL 09 03 24 (6)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	WL 09 03 24	(6)
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	WL 09 03 24	(6)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	(MD) Ed.	09 03 25 (Xb)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



21



09-03-25

VB

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



send to Deloside

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/03/25

⑥

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/03/25 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.03.25

DART AEROSPACE LTD	Work Order:	46667
Description: DOUBLER	Part Number:	D2992-1
Inspection Dwg: D2992 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

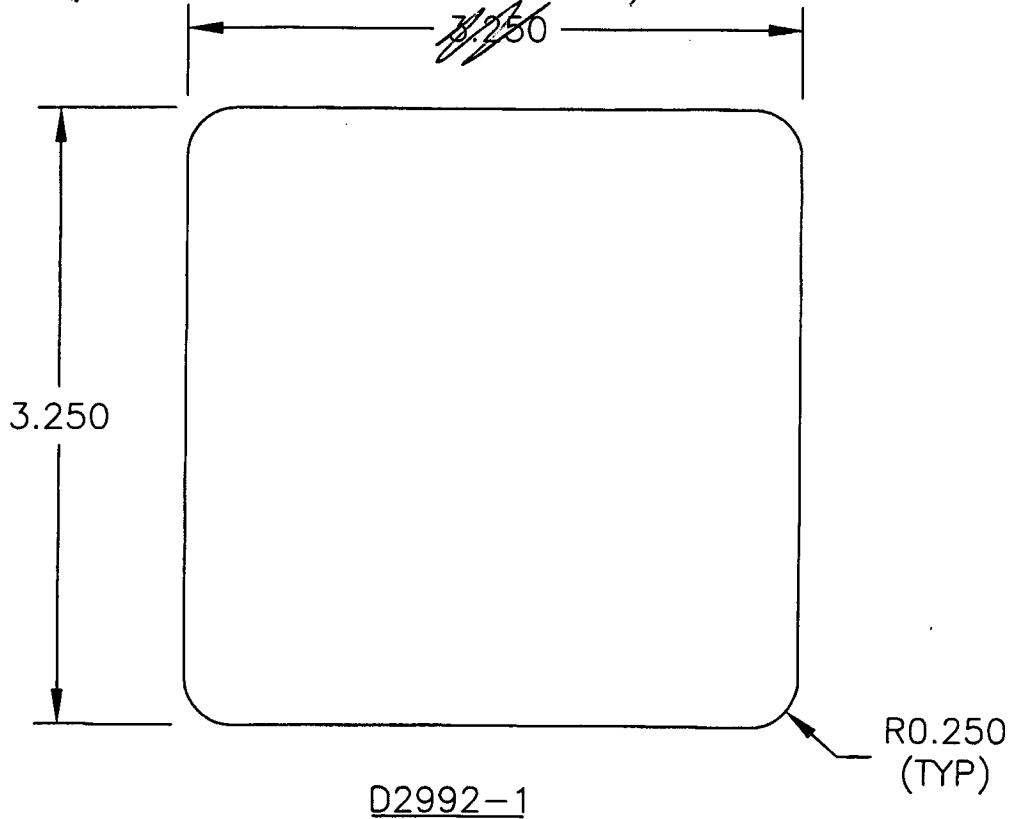
X First Article Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>R.S.</u>	Prototype Approval:	<u>N/A</u>
Date:	09.03.24	Date:	09.03.24	Date:	<u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	.	New Issue	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE 02.01.21	TITLE DOUBLER		SCALE 1:1
A	02.01.21	NEW ISSUE	

RELEASED
02.01.25 *[initials]***UNDER REVIEW**07/03/18 *MP*NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED